



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

RBW6705G00231-3G
Job Sheet 198703



Part No: RBW6705G00231-3G

Job Qty: 1 pcs

Part Name: AW139 Main Rotor Control Tool



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 8/1/19

Job Tracking No:

Due Date: 8/23/19

Created By: Marie Lajeunesse

Type: SOLD

Description: ORDER 17721

Note: DWG RBW6705G00231-3G Rev 2 IPP Rev. A 19.08.01 New issue DP Verify DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Small Fab - Issue SN	1 pcs	8/23/19		0.00	0.28	Small Fab - 1		MLL
							Small Fab - 2		
							Small Fab - 3		
							Small Fab - 4		
							Small Fab - 5		
							Small Fab - 6		
							Small Fab - 7		
							Small Fab - 8		
100	Small Fab - 2 - B4B	1 pcs	8/23/19		0.00	0.25	Small Fab - 1 - B4B		MLL
							Small Fab - 2 - B4B		
							Small Fab - 3 - B4B		
							Small Fab - 4 - B4B		
							Small Fab - 5 - B4B		
							Small Fab - 6 - B4B		
							Small Fab - 7 - B4B		
							Small Fab - 8 - B4B		
110	QC 5	1 pcs	8/23/19		0.00	0.00	QC 5 - 10		
							QC 5 - 12		
							QC 5 - 17		
							QC 5 - 18		
							QC 5 - 19		
							QC 5 - 22		
							QC 5 - 24		
							QC 5 - 3		
							QC 5 - 43		
							QC 5 - 49		
							QC 5 - 51		
							QC 5 - 58		
							QC 5 - 68		
							QC 5 - 9		
							QC 5 - 50		



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL.: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Container No: S215015



Part: RBW6705G00231-3G

Job No: 198703

Serial No/Batch: S215015

Revision: 2

Inspector:

Exp Date:

Instructions:

Date: 08/19/19

Plex 8/21/19 10:42 AM dart.leclair.mathieu

SEP 19 2019 9:59

				QC 5 - 30	
				QC 5 - 40	
				QC 5 - 61	
				QC 5 - 81	
130	Packaging 3-1 - Stock - B4B	1 pcs	8/23/19	0.00 0.00	Packaging 3 - 1 - B4B
					Packaging 3 - 2 - B4B
					Packaging 3 - 3 - B4B
					Packaging 3 - 4 - B4B
					Packaging 3 - 5 - B4B
					Packaging 3 - 6 - B4B
					Packaging 3 - 7 - B4B
					Packaging 3 - 8 - B4B
					Packaging 3 - 9 - B4B
					Packaging 3 - 10 - B4B
					Packaging 3 - 11 - B4B
					Packaging 3 - 12 - B4B
					Packaging 3 - 13 - B4B
					Packaging 3 - 14 - B4B
					Packaging 3 - 15 - B4B
					Packaging 3 - 16 - B4B
					Packaging 3 - 17 - B4B
					Packaging 3 - 18 - B4B
					Packaging 3 - 19 - B4B
					Packaging 3 - 20 - B4B
					Packaging 3 - 21 - B4B
					Packaging 3 - 22 - B4B
					Packaging 3 - 23 - B4B
					Packaging 3 - 24 - B4B
					Packaging 3 - 25 - B4B
					Packaging 3 - 26 - B4B
					Packaging 3 - 27 - B4B
					Packaging 3 - 28 - B4B
					Packaging 3 - 29 - B4B
					Packaging 3 - 30 - B4B
					Packaging 3 - 31 - B4B
					Packaging 3 - 32 - B4B
					Packaging 3 - 33 - B4B
					Packaging 3 - 34 - B4B
					Packaging 3 - 35 - B4B
					Packaging 3 - 36 - B4B
140	QC 21 - FG	1 pcs	8/23/19	0.00 0.00	QC 21 - FG - 21
					QC 21 - FG - 70
					QC 21 - FG - 53

DAS

28

9-89

DAS

21

9-89

SEP 20 2019

RBOOLA

Part Op 90 - Issue S/N

Descriptions: 100 - (Small Fab) 1-Engrave placard RB41011 using marktronic engraver 2-Transfer drill Dart placard RB41011 into Pelican case APP-1400-E 3-Deburr holes and remove chips from case. 4-Rivet Dart placard to Pelican case 5-Glue placard RBW6705G00231-3G-13 to RBW6705G00231-3G-11 foam as per DWG. 6-Glue foam to case and pack case as per DWG.

110 - (QC5- Inspect part completeness to step on W/O)

130 - (Identify as per dwg & Stock Location: _____)

140 - (QC21- Final Inspection - Work Order Release)

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
RB41011	Dart Tooling Placard, Aluminum	1 pcs (1 ea)	90-Small Fab - Issue SN	5021040
63 38 90183A213	BLIND RIVET FLAT WASHER ALUMINUM, ROUND, FOR 1/8" RIVET BODY DIA., 3/8" OD	4 Ea (4 ea)	100-Small Fab - 2 - B4B	505-8755
97447A130	Aluminum Blind Rivet W/Aluminum Mandrel Dorned, 1/8" Dia., 0.313"-0.375" Material Thickness	4 Ea (4 ea)	100-Small Fab - 2 - B4B	5054330
APP-1400-E	Case	1 Ea (1 ea)	100-Small Fab - 2 - B4B	5214973
RBW6705G00231-3G-11	Lid Foam used in case APP-1400-E	1 Ea (1 ea)	100-Small Fab - 2 - B4B	5214969
158 RBW6705G00231-3G-13	Placard W/Adhesive Back	1 pcs (1 ea)	100-Small Fab - 2 - B4B	5211197
RBW6705G00231-3G-9	Bottom Foam use in case APP-1400-E	1 Ea (1 ea)	100-Small Fab - 2 - B4B	5214971
144A RBW6705G03131-3G	Locking Tool Main Rotor Damper	1 pcs (1 ea)	100-Small Fab - 2 - B4B	5209737
143 RBW6705G03231-3G	Clinometer Support Tool Main Rotor	1 pcs (1 ea)	100-Small Fab - 2 - B4B	5209256
AP1BD 158 RBW6705G03331-3G	Positioning Tool Main Rotor Rotating Scissor	1 pcs (1 ea)	100-Small Fab - 2 - B4B	5209678

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Small Fab - Issue SN	RB41011	1	260	0
100-Small Fab - 2 - B4B	90183A213	4	471	0
	97447A130	4	80	0
	APP-1400-E	1	12	0
	RBW6705G00231-3G-11	1	0	0
	RBW6705G00231-3G-13	1	0	0
	RBW6705G00231-3G-9	1	0	0
	RBW6705G03131-3G	1	0	0
	RBW6705G03231-3G	1	0	0
	RBW6705G03331-3G	1	0	0

Part Specifications

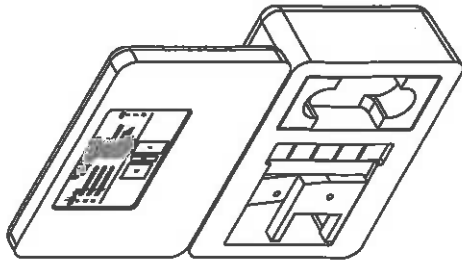
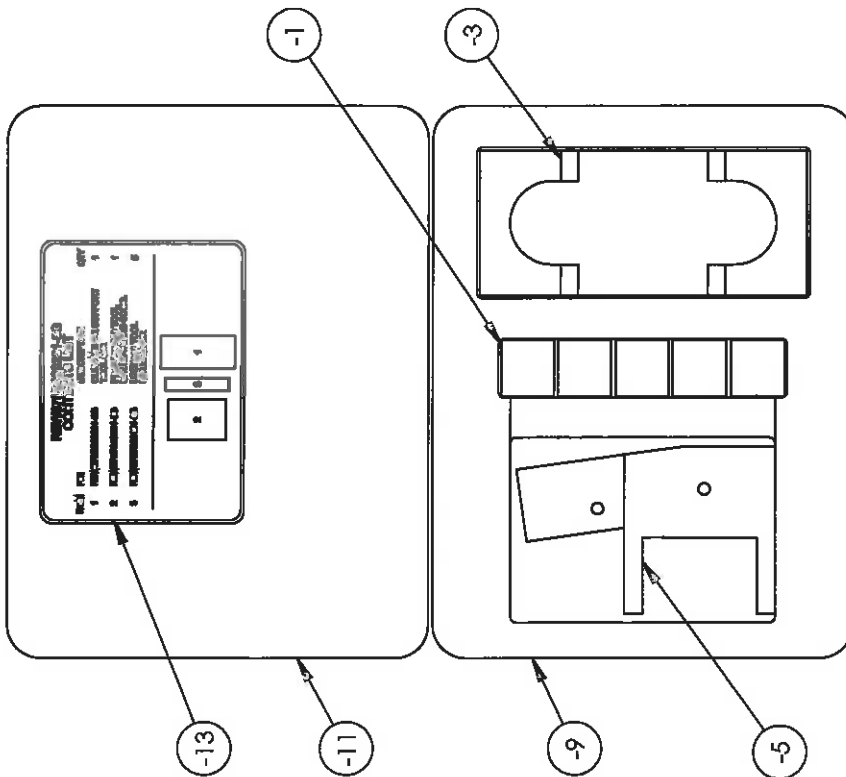
Specifications could not be found.

Plex 8/21/19 10:42 AM dart.leclair.mathieu

This drawing, specifications, and concepts contained here in are the sole property of DART Aerospace, Inc. and are not to be used in any fashion without the prior written permission of DART Aerospace Engine, OR.

REVISIONS

REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED
1		-9 CHD CENTER POCKET DEPTH WAS ∇ 3.00 IS ∇ 3.25, ADDED ADDITIONAL CUTOUT BETWEEN CENTER AND END POCKET FOR LANYARD CABLE ENDS, CENTERED CENTER & END POCKETS IN FOAM, ADDED R.125 TYP. FOR ALL CORNERS.	9/26/2012	RJC	SE
2	15-0172	-11 CHD DIM WAS ∇ .063 IS ∇ .13 CHD MATERIAL WAS EGGSHELL BLACK IS Y20 BLACK. -13 CORRECTED DESCRIPTION WAS POSITIONING TOOL M/R ROTATING SCISS. IS POSITIONING TOOL M/R ROTATING. CHD DESCRIPTION WAS PLACARD W/ADHESIVE BACK IS PLACARD. -15, -17, & -19 ADDED TO DWG.	6/1/2015	RJC	JAG



ASSY QTY	B/O	Part #	QTY.	Description	Material	B/O INFORMATION OR SPECIFICATIONS	PG.
		-1	1	LOCKING TOOL M/R DAMPER		RBW6705G03131-3G	1
		-3	1	CLINOMETER SUPPORT TOOL M/R		RBW6705G03231-3G	1
		-5	1	POSITIONING TOOL M/R ROTATING SCISS.		RBW6705G03331-3G	1
	B/O	-7	1	CASE	PLASTIC	PELICAN #APP-1400-E BLACK	N/S
	B/O	-9	1	BOTTOM FOAM	Y20 BLACK	4 X 9-1/8 X 12 IR SPECIALTY FOAM	2
	B/O	-11	1	LID FOAM	Y20 BLACK	1-1/4 X 9-1/8 X 12 IR SPECIALTY FOAM	3
	B/O	-13	1	PLACARD	PALSTIC	1/16 X 4-1/4 X 6	4
	B/O	-15	1	DART PLACARD	ALUMINUM	RB41011	N/S
	B/O	-17	4	RIVET	ALUMINUM	Ø1/8 X .525 (MCMASTER-CARR #97447A130)	N/S
	B/O	-19	4	BLIND RIVET WASHER	ALUMINUM	Ø1/8 (MCMASTER-CARR #90183A213)	N/S

TITLE

M/R CONTROL TOOL

DWG NO.

RBW6705G00231-3G

REV

2

DRAWN BY:

CLOUGH

APPROVED

D. Weil

UNLESS OTHERWISE SPECIFIED

ALL DIMENSIONS ARE IN INCHES

DECIMALS ARE IN INCHES

FRACTIONS ARE 1/8

ANGLES ARE 1/16

FINISH

SPEC

1. BREAK ALL SHARP EDGES .015 X 45°

2. DIMENSIONAL LIMITS APPLY AFTER PLATING

USED ON MODEL

AW139

SCALE

1:4

DATE

3/23/2010

SHEET 1 OF 4